

Work Order ID 87197

87197

Page 1

July-11-12 10:09:01 AM

Item ID: D350-604-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Rear Locker Extender

Start Date: 7/16/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/24/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

V

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2273	F
D350-604-041	B

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D350-604-041

CHG003 for D2273 rev.E (new gelcoat)

CHG004 for D2273 rev.F (new primer)

110

110

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O:

17548 Description: D350-604-041 Rear locker extender.

Supplier: Delastek

Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B 122441

4 x 2600-LW Retaining washers - Ship to Delastek B 122452 SF

SCRAP

SCRAP

120726

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 87197

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Page 2

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Accept

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1

Cust Item ID:

Required Date: 8/24/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.

Russell C

130

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Check hole locations to template. DT 8824 Check process sheet and audit.

Pls >

140

140

Small Fab

Small Fab

0.00

Memo

0.00

INSTALL DECALS AS PER DWG

W/O: 87197

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-604-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: *Art* Date: 12/09/27

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-8-8	130	Found during inspection a crack on the inside of the locker, re-supply (See Attached Pictures)	DAS 16 9-89 Q51042 12/08/08	Retain Part Back to supplier for crack Rma # <u>820</u>	12/08/08	<i>Go 12/08/08</i>	DAS 16 9-89 12/08/08 051042	DAS 16 9-89 12/08/08 051042
				Solve Composites				

NOTE: Date & initial all entries

Work Order ID 87197

July-11-12 10:09:01 AM

87197

Page 3

Item ID: D350-604-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Rear Locker Extender

Stop

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Start Date: 7/16/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/24/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Quality Control

160

Packaging

0.00

160

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-604-041

Location: _____

PPP Rev: _____

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Quality Control

Memo

0.00

021209124

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-11-12 10:09:01 AM

Page 1

Work Order ID: 87197

Parent Item: D350-604-041

Start Date: 7/16/12

Required Date: 8/24/12

Parent Item Name: Rear Locker Extender

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF
521 DD verf:JLM IPP REV:S 12.04.04 AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2600-6 Camlock Stud		Purchased	No			110	Each	199.0000		4	4		
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST380			199						
				120077			8						
				121556			4						
				122317			42						
				122335			145						
2600-LW Camloc Retaining Washer		Purchased	No			110	Each	319.0000		4	4		
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST380			316						
				121524			116						
				122317			200						
				ST381			1						
				121287			1						
				ST398			2						
				120648			2						
D2268 Decal		Manufactured	No			140	Each	31.0000		1	1		
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST007			20						
				80010			20						
				ST009			11						
				69592			2						
				78908			9						

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Picklist Print

July-11-12 10:09:01 AM

Page 2

Work Order ID: 87197**Parent Item:** D350-604-041**Parent Item Name:** Rear Locker Extender**Start Date:** 7/16/12**Required Date:** 8/24/12**Start Qty:** 1.00**Required Qty:** 1.00**D2269**

Manufactured No

Each 25.0000

1

Decal

Location **Loc Qty** **Loc Code**

ST007 20 _____

80011 20 _____

ST009 5 _____

78920 5 _____

D350-604-041P

Purchased No

110 Each 0.0000

1 **1**

Rear Locker Extender

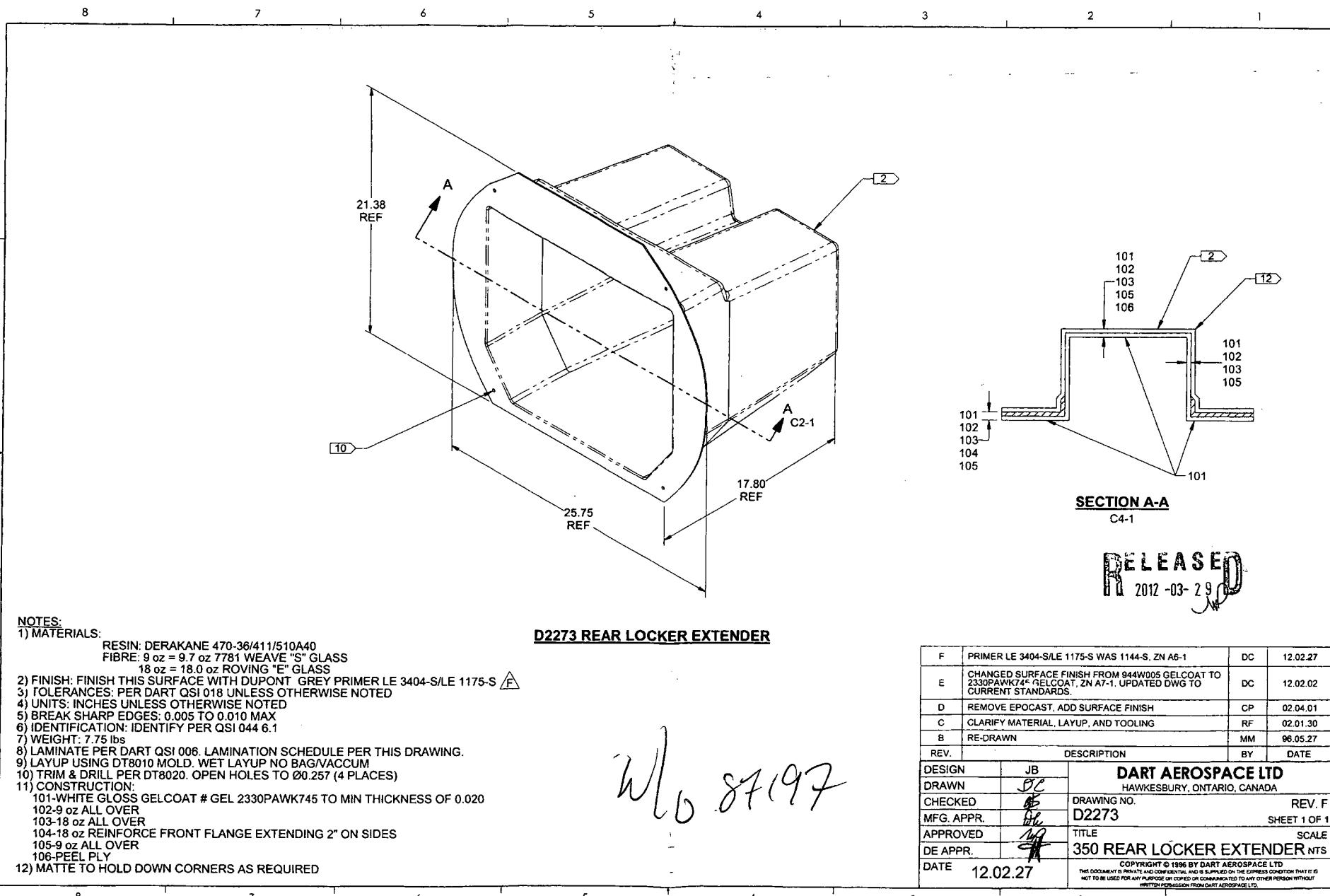
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear	General										
	Bending	Bend	Grain	Ovalized				Pressure/Forced			
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance				Temperature/Cure			
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect				Weld			
	Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing				Wrong Stock Pulled			
	Cuffs	Contamination	Maintenance	Part Moved							
	Heat Treat	Countersink	Mislabeled	Positioned Wrong							
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge							
	Ripples in Bend	Drill Holes	Offset								
	Torque Waves in Extrusion	Drawing	Out of Calibration								
	Turning Sequence	Finish	Out of Sequence								
	Wave/Twist in Tube	Folio	Outside Dimensions								

Solve Composites
29 Distribution Way
Suite 101
Plattsburgh, NY 12901
Phone: 518-324-3838
Fax: 518324-5530

Packing List

Bill Dart Aerospace
To: 1270 Aderdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace
To: 1270 Aderdeen Street
Hawkesbury, ON K6A 1K7
Canada

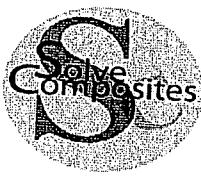
Shipment No: 13406
Shipment Date: 08/03/12
Ship Via: Fedex Freight
Order Number: 11936
Order Date: 07/26/12

Customer Code: DART
Phone: (613) 632-9577
PO Number: 17548
Terms: Net 30 Days

n	Quantity						Revision	Job Number
	Open	Shipped	Back Ord	Canceled	Unit	Description		
	5	4	1		EA	D350-604-041P D350-604-041P Rear Locker Extender	F	11936-01

Packing Clerk's Initials
Solve Composites

Received In Good Order By
Dart Aerospace



Certificate of Conformance

Solve Composites

29 Distribution Way

Plattsburgh, New York, 12901

USA

Dart Aerospace Order Number: 17548

Part Number: D2273

Quantity: 1

Drawing Number: D2273, DT8020

Serial Number (s): 0004

Date: August 7, 2012

Non-Conformances: None

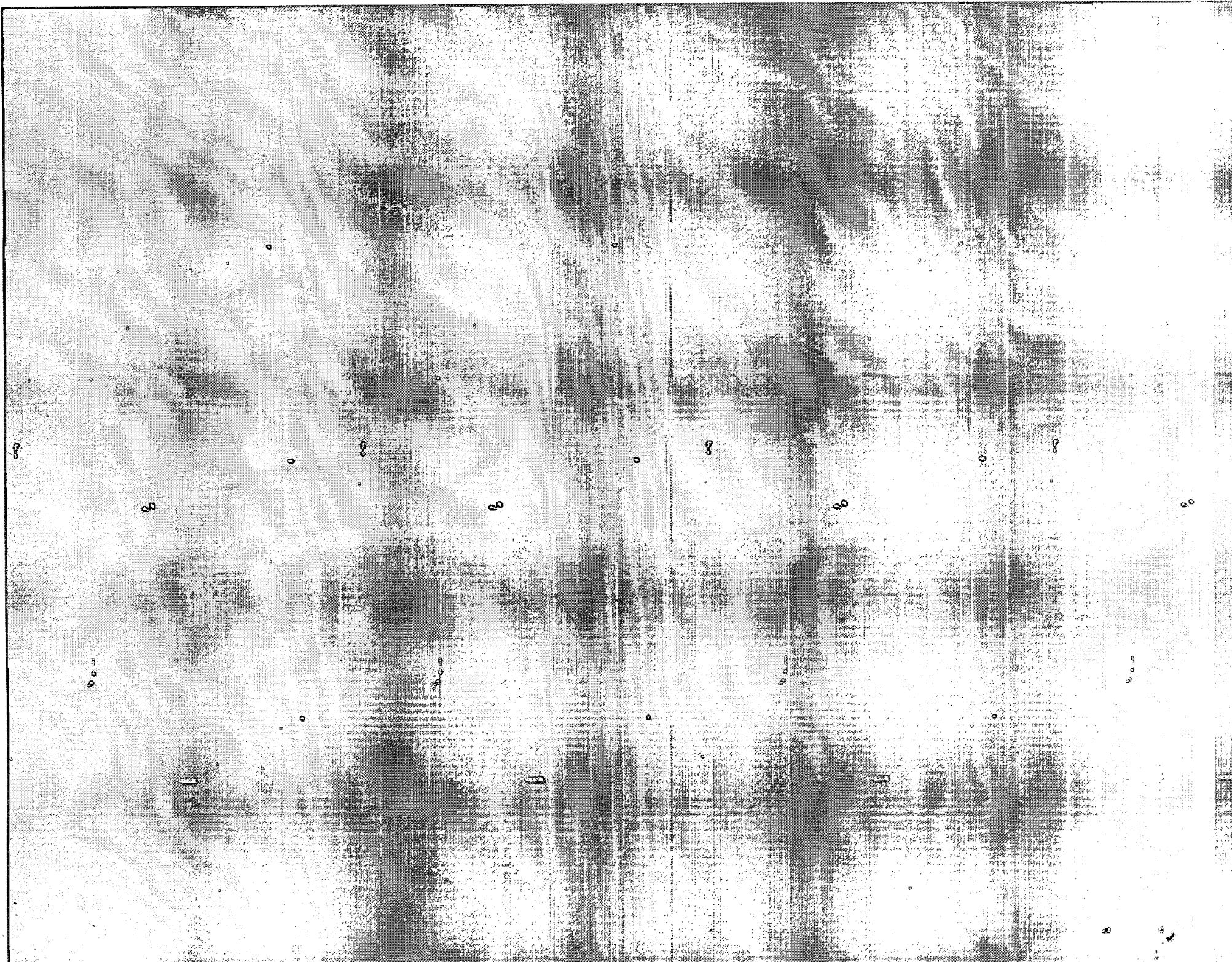
This is to certify that the parts identified above conform to all applicable drawings and/or specifications as evidenced by reports on file, and that all other purchase order and quality requirements have been met.



Jerry Reyell

Project Manager

Solve Composites



D&T Onospace

Rma 820

N° DE COMMANDE - ORDER NO.		DÉP. - DEPT.	DATE	12/08/08
VENDU À - SOLD TO		EXPÉDIÉ À - SHIP TO Salvee Composites 29 Distribution Way Ridderburgh, New York 12901 U.S.		
ADRESSE - ADDRESS		ADRESSE - ADDRESS		
DATE D'EXPÉDITION - SHIPPING DATE	VIA	CONDITIONS - TERMS	N° D'ENR. DE TAXE - TAX REG. NO.	VENDEUR - SALESPERSON
		attn: Jersey	518-324-3238	
1 neoplycker cracked.				
<p>Thanks Chantel</p>				
RMA 820				
TPS/GST				
TVP/PST				
230930	SIGNATURE	N° LIC. - LIC. NO.	TOTAL	

230930

SIGNATURE

Nº LIC. - LIC. NO.

TOTAL

FORMULAIRE DE VENTE – SALES ORDER

Chantal Lavoie

From: Isam El-Kassis <ielkassis@dartaero.com>
Sent: August 8, 2012 9:42 AM
To: 'Eric Downing'; Chantal Lavoie; 'Melanie Fauteux'
Subject: FW: D350 rear lockers

RMA for returning the rear locker,

Please ship back to them

Isam

From: Jerry Reyell [<mailto:JReyell@solvecomposites.com>]
Sent: Wednesday, August 08, 2012 9:40 AM
To: 'Isam El-Kassis'
Cc: cathy@solvecomposites.com; Alisa Langille
Subject: RE: D350 rear lockers

Return to Solve using RMA 820.

Jerry Reyell
Project Manager
Solve Composites
29 Distribution way
Suite 101
Plattsburgh, NY 12901
518-324-3838
Extension 105

From: Isam El-Kassis [<mailto:ielkassis@dartaero.com>]
Sent: Wednesday, August 08, 2012 8:44 AM
To: 'Jerry Reyell'
Subject: RE: D350 rear lockers

Hi Jerry,

It is repairable, but we have to send it back to you, we cannot do it in house (crack in the interior gel coat something like a hole or dent)

Regards,

From: Jerry Reyell [<mailto:JReyell@solvecomposites.com>]
Sent: Wednesday, August 08, 2012 8:06 AM
To: 'Alisa Langille'
Cc: 'Isam El-Kassis'; Eric Downing
Subject: RE: D350 rear lockers
Importance: High

Can I please get some pictures of this locker which will show what the damage is?

Jerry Reyell
Project Manager
Solve Composites
29 Distribution way
Suite 101
Plattsburgh, NY 12901
518-324-3838
Extension 105

From: Alisa Langille [<mailto:alangille@solvecomposites.com>]
Sent: Wednesday, August 08, 2012 7:59 AM
To: Jerry Reyell
Subject: FW: D350 rear lockers
Importance: High

From: Isam El-Kassis [<mailto:ielkassis@dartaero.com>]
Sent: Wednesday, August 08, 2012 7:56 AM
To: 'Eric Downing'; Alisa Langille
Cc: 'Melanie Fauteux'
Subject: RE: D350 rear lockers
Importance: High

Thanks Eric,

Hi Alisa,

One of the four rear lockers are rejected by our QC, if the decision is (part scrap), we would like to have a replacement for it and ask for RMA to return it.

Melanie,

Please contact sales for shipping the three rear locker ASAP.

Regards,

Isam

From: Eric Downing [<mailto:edowning@dartaero.com>]
Sent: Wednesday, August 08, 2012 7:48 AM
To: 'Isam El-Kassis'; 'L Lacelle'
Cc: psmith@dartaero.com
Subject: RE: D350 rear lockers

They are all checked QTY 1 in my opinion is scrap or not suitable for shipping. Its red tagged and I am going to place it in quarantine. But the three others are able to be shipped out.

Eric Downing

From: Isam El-Kassis [<mailto:ielkassis@dartaero.com>]

Sent: Wednesday, August 08, 2012 7:09 AM

To: 'Eric Downing'

Subject: FW: D350 rear lockers

Hi Eric,

Are they ready to go now, all checked for shipping!!

Isam

From: Eric Downing [<mailto:edowning@dartaero.com>]

Sent: Wednesday, August 08, 2012 7:07 AM

To: 'Alisa Langille'; 'Isam El-Kassis'

Cc: psmith@dartaero.com; 'L Lacelle'; jreyell@solvecomposites.com

Subject: RE: D350 rear lockers

Alisa

That is much appreciated.

Thanks a ton.

Eric Downing

From: Alisa Langille [<mailto:alangille@aol.com>]

Sent: Tuesday, August 07, 2012 7:56 PM

To: 'Eric Downing'; 'Isam El-Kassis'

Cc: psmith@dartaero.com; 'L Lacelle'; jreyell@solvecomposites.com

Subject: RE: D350 rear lockers

Eric

Not a problem. We will ensure that the serial number is on the bottom with permanent

Alisa

From: Eric Downing [<mailto:edowning@dartaero.com>]

Sent: Tuesday, August 07, 2012 3:51 PM

To: 'Alisa Langille'; 'Isam El-Kassis'

Cc: psmith@dartaero.com; 'L Lacelle'

Subject: RE: D350 rear lockers

Hello Alisa

I am Eric Downing, the QC Coordinator here at Dart, and I have notice in your paper work you have sent us that you have assigned serial numbers to each one of the rear lockers. When I was inspecting the lockers I didn't notice those numbers on the parts. In the future could we have them stenciled or written on with permanent marker on the underside in the middle approx. on the large flange on top of the primer for our traceability. Like you can see in the attached picture.

I hope that this is not too much trouble.

Thanks

Eric Downing
QC Corrdinator
Dart Aerospace LTD

From: Alisa Langille [<mailto:alangille@solvecomposites.com>]
Sent: Tuesday, August 07, 2012 3:25 PM
To: 'Isam El-Kassis'
Cc: 'Eric Downing'
Subject: RE: D350 rear lockers

Isam
Attached is the required paperwork. We will work on the notes below to make sure the next set is better. The 3 shipped today before this email.

Alisa

From: Isam El-Kassis [<mailto:ielkassis@dartaero.com>]
Sent: Tuesday, August 07, 2012 3:13 PM
To: Alisa Langille
Cc: 'Eric Downing'
Subject: FW: D350 rear lockers
Importance: High

Hi Alisa,

Please make sure the following notes are achieved,
Also I would like to add on the Paperwork are needed for every shipment.

Regards,

Isam,

From: Eric Downing [<mailto:edowning@dartaero.com>]
Sent: Tuesday, August 07, 2012 1:18 PM
To: Isam El-Kassis; psmith@dartaero.com; 'Bill Beckett'; 'Mike Petsche'
Cc: David Shepherd; 'L Lacelle'
Subject: D350 rear lockers

I have just finished inspecting the rear lockers that have arrived in. I believe that they are from BFG(Solve) in Plattsburg.

I have found the following

- The edges are ruff need to be slightly de-bured here before being released to a customer
- The primer fiber glass isn't the smoothest but is acceptable this time only
- The rads have some build up but nothing that can affect the fit
- QTY X 1 has a crack inside the locker in the gel coat looks to me as a void between the gel coat and the fiberglass
- The gel coat finish is NOT smooth like delastic's finish but should be acceptable only a customer might notice a different between a previous rear locker
- They fit the locating tool

Please see the pictures to help show what has been noticed. Also there is NO PAPER WORK so I can't release the parts to go further in our process.

If there are any questions please come and see me or I can supply with more pictures.

Thanks

Eric Downing
QC Corrdinator
Dart Aerospace LTD



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO17548

Purchase Order Date 7/26/12

PO Print Date 8/08/12

Page Number 1 of 2

Order From : VU-SOL001

SOLVE COMPOSITES
29 DISTRIBUTION WAY, SUITE 101
PLATTSBURGH, NEW YORK 12901
UNITED STATES OF AMERICA

Contact Name	Buyer	Linda Lacelle
Vendor Phone	Requisition Nbr	
Vendor Fax	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	USD
	FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D350-604-041P	Rear Locker Extender	8/10/12 Yes	1.00 Each	FedEx PI collect	\$250.0000	\$250.00
		Special Inst:	PER DRWG D2273 REV.F				
2	D350-604-041P	Rear Locker Extender	8/10/12 Yes	1.00 Each	FedEx PI collect	\$250.0000	\$250.00
		Special Inst:	AS ABOVE				
3	D350-604-041P	Rear Locker Extender	8/10/12 Yes	1.00 Each	FedEx PI collect	\$250.0000	\$250.00
		Special Inst:	AS ABOVE				
4	D350-604-041P	Rear Locker Extender	8/10/12 Yes	1.00 Each	FedEx PI collect	\$250.0000	\$250.00
		Special Inst:	AS ABOVE				
5	D350-604-041P	Rear Locker Extender	8/10/12 Yes	1.00 Each	FedEx PI collect	\$250.0000	\$250.00
		Special Inst:	AS ABOVE				

RMA 820
Attn: Jerry Regell
30" X 24" X 24"
X 15LB

7/26/12
Ref: P017548
Dep:

REFERENCE ONLY
Date: 08Aug12
Wgt: 15.00 LBS
CV:
of Pkgs: 1 0.00
Svcs: INT'L PRIORITY ISR
TRCK: 9018 2254 0821
SHIPPING:
SPECIAL:
HANDLING:
TOTAL:
491.25
51.75
0.00
483.00

